

# Work Order ID 80257

**\*80257\***

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Item ID: D2804-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Bracket Assembly  
 Start Date: 15/02/2012 Start Qty: 5.00 **\*5\*** Cust Item ID:  
 Required Date: 29/02/2012 Req'd Qty: 5.00 **\*5\*** Customer:  
 Reference:

Approvals: Process Plan: M.L.S Date: 12/02/16 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D2804	Rev C								
100	Small Fab	0.00							
<b>*100*</b>									
Small Fab	Memo	0.00							
Small Fab	Press D2805-1 Into arm as per Dwg D2804								
110	QC5- Inspect part completeness to step on W/O	0.00							
<b>*110*</b>									
QC	Memo	0.00							
Quality Control									
120	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
<b>*120*</b>									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: <u>1h00</u> OVEN TEMPERATURE: <u>m120222</u>								
	<u>1h30</u> FINISH TIME: <u>320°F</u>								

12/03/29 (5)

12/03/29

(45)  
41

5 2P 12/03/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 80257****\*80257\***

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Item ID: D2804-041

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Bracket Assembly

Start Date: 15/02/2012 Start Qty: 5.00

**\*5\***

Cust Item ID:

Required Date: 29/02/2012 Req'd Qty: 5.00

**\*5\***

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC3- Inspect Part Finish	0.00							
<b>*130*</b>									
QC	Memo	0.00							
Quality Control									
140		0.00							
<b>*140*</b>	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Press D2809 into arm as per Dwg D2804								
150		0.00							
<b>*150*</b>	Small Fab								
Small Fab	Memo	0.00							
Small Fab	1-Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2804 2-Assemble as per Dwg D2804.								

5 BL 12309

EP 12/03/12 ⑤

EP 12/03/12 ⑤

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

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**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**\*5\***

**Cust Item ID:**

**\*5\***

**Customer:**

**Reference:**

Run Start \*NR1\*

Stop \*NR2\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

**Insp.  
Stamp**

0.00

**\*160\***

0.00  
0.00

QC

## Memo

0.00

## Quality Control

0.00

**\*170\***

## Memo

0.00

### Packaging

## Packaging

0.00

**\*180\***

## Memo

0.00

QC

## Quality Control

112-03 30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 80257

\*80257\*

Parent Item: D2804-041

\*D2804-041\*

Parent Item Name: Bracket Assembly

Start Date: 15/02/2012

Required Date: 29/02/2012

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP F05.03.30MS21043-3 was MS21042L3KJ/JLM  
IPP Rev:G As per Rev C 06-11-08 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2804-1		Manufactured	No			100	Each	10.0000	1	5			
*D2804-1*									**				
Bracket													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST148				10					
				79083				8					
				79179				2					
D2805-1		Manufactured	No			100	Each	24.0000	1	5			
*D2805-1*									**				
Stop													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				24					
				79525				24					
NAS1515H3		Purchased	No			100	Each	286.0000	4	20			
*NAS1515H3*									**				
Washer													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST277				286					
				118078				6					
				118384				11					
				119438				4					
				120142				99					
				120518				166					

5  
5  
5  
20  
20

12/03/29  
12/03/29  
12/03/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Work Order ID: 80257

**\*80257\***

Parent Item: D2804-041

**\*D2804-041\***

Parent Item Name: Bracket Assembly

Start Date: 15/02/2012

Required Date: 29/02/2012

Start Qty: 5.00

Required Qty: 5.00

AN3C16A

Purchased

No

150

Each

109.0000

2

10

**\*AN3C16A\***

Bolt

\*\*

*EP 12/03/12*

Location

Loc Qty

Loc Code

ST352

109

115835

1

118422

4

119641

4

120498

100

D2809

Manufactured

No

150

Each

23.0000

1

5

**\*D2809\***

Bushing

\*\*

*EP 12/03/12*

Location

Loc Qty

Loc Code

GA

7

72735

7

ST018

16

34035

12

77292

4

80557  
*(5X)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 80257

Parent Item: D2804-041

Parent Item Name: Bracket Assembly

**\*80257\***

**\*D2804-041\***

Start Date: 15/02/2012

Required Date: 29/02/2012

Start Qty: 5.00

Required Qty: 5.00

MS21043-3

Purchased

No

150

Each

1,340.000

2

10

**\*MS21043-3\***

Nut

\*\*

*EP 2/03/12*

*10*

Location

Loc Qty

Loc Code

FG

72

103691

72

GA

400

120693

400

ST300

373

119901

373

ST301

495

118077

2

118614

441

118686

30

119758

22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

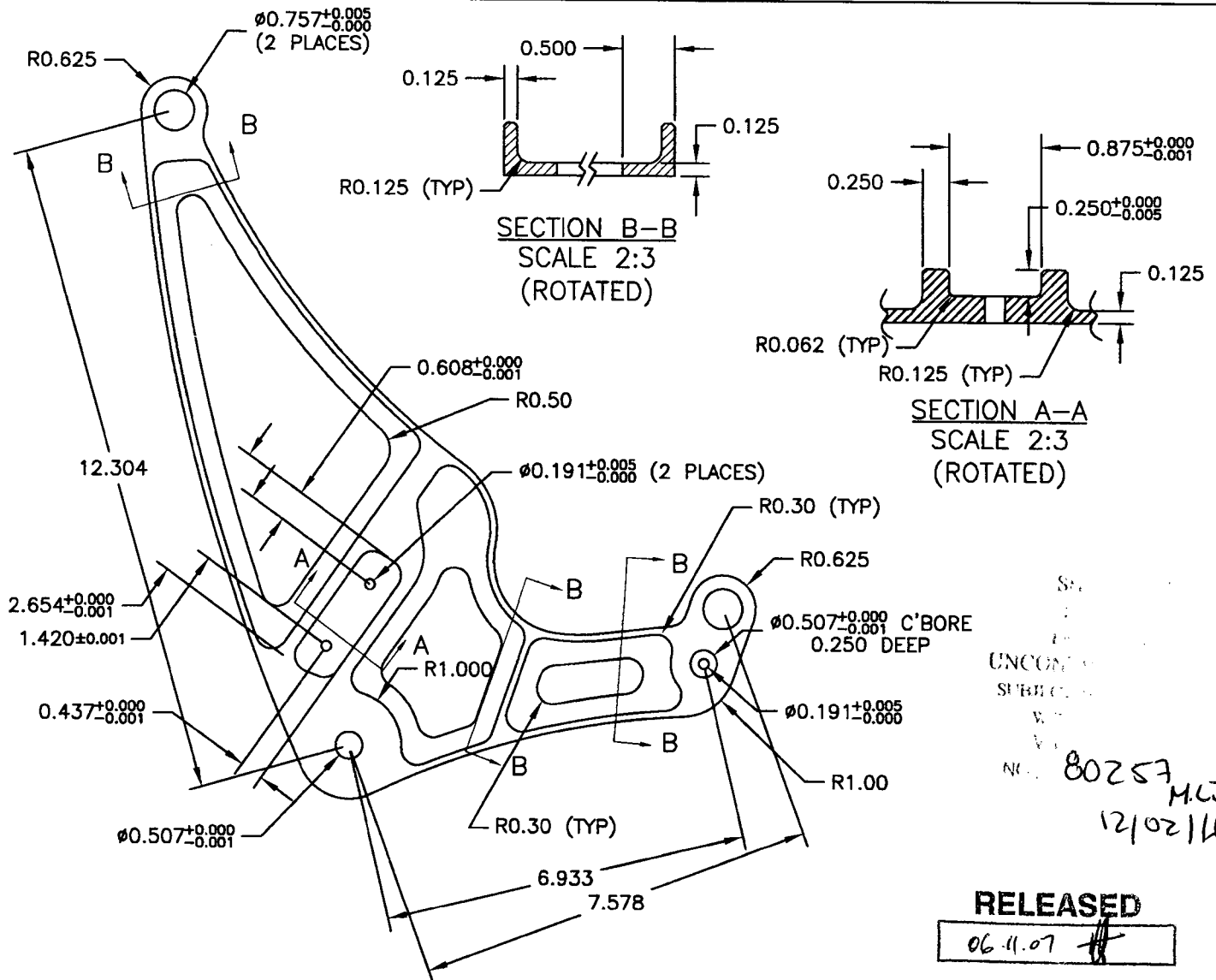
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2804	REV. C SHEET 1 OF 2
DATE 06.10.16		TITLE STA 155 BRACKET	SCALE 1:3
A	00.11.07	NEW ISSUE	
B	04.11.22	ADD CUTOUTS & -043/-044	
C	06.10.16	CHANGE GEOM. TO ADD CLEARANCE	

**D2804-1 BRACKET (SHOWN). D2804-2 BRACKET (OPPOSITE)**

- 1) MACHINE PER DRAWING FILE "D2804-1C.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

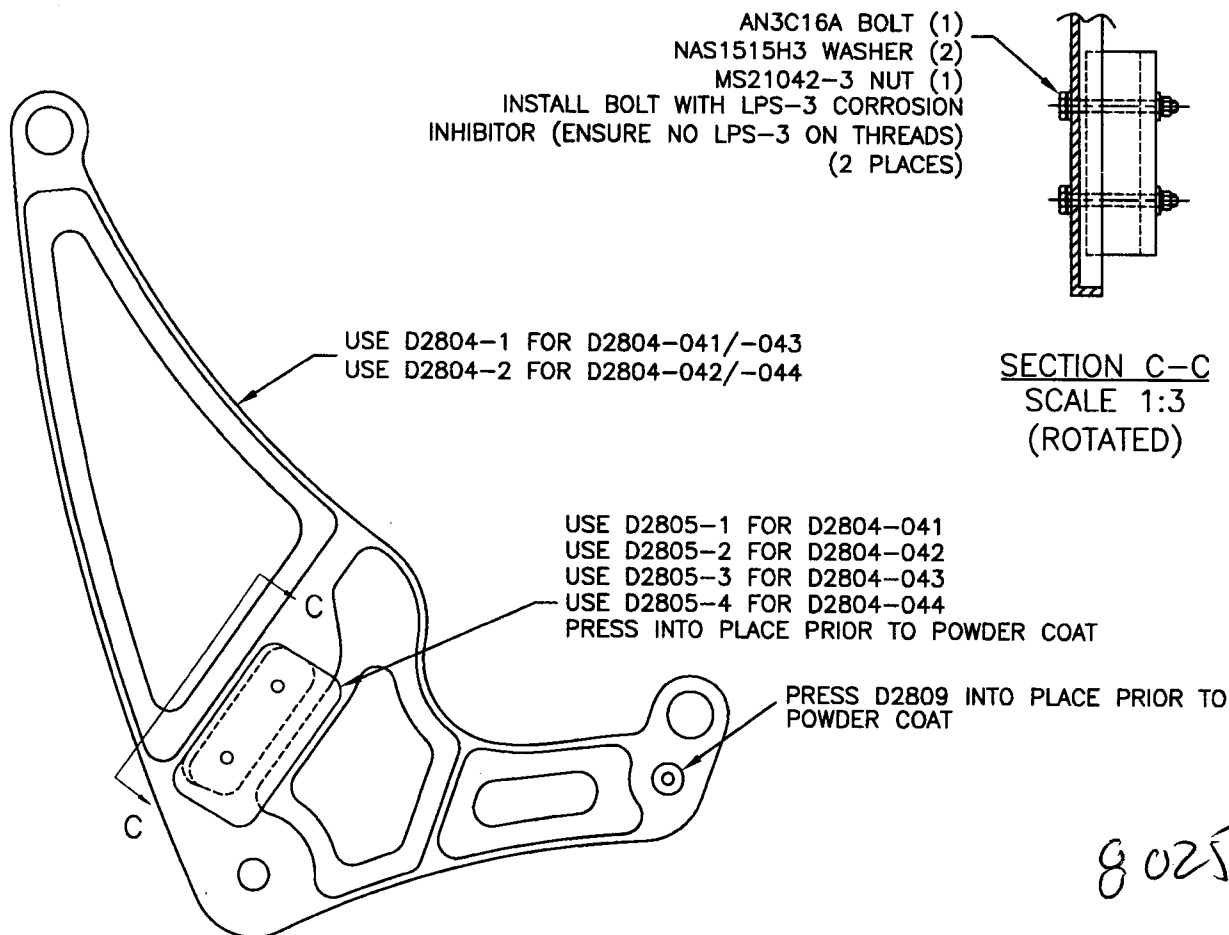
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2804	REV. C SHEET 2 OF 2
DATE 06.10.16		TITLE STA 155 BRACKET	SCALE 1:3



SECTION C-C  
SCALE 1:3  
(ROTATED)

80257

RELEASED

06.11.07

D2804-041/-043 BRACKET ASS'Y (SHOWN)

D2804-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries